

Work Order ID 79033

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79033

Page 1

Item ID: D1049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 18/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1049	Rev A								

100		0.00							
100	SHEAR								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blanks: 2.000" long			<u>ork 12/01/26</u>		<u>20</u>	<u>0</u>		
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio FA217 & Dwg D1049 2-Deburr					<u>20</u>	<u>0</u>	<u>29/12/01/28</u>	
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control						<u>20</u>	<u>0</u>	<u>29/12/01/28</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 01/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 10:00
 OVEN TEMPERATURE: 3200 F
 FINISH TIME: 10:30

MU5128

20X0 M-L 12/01/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Item Name: Saddle
 Start Date: 18/01/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>GA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

20x of all 12/01/30
 counted

12/1/30 sf (20)

12/2/11 sf

12-01-31
 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79033

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Parent Item: D1049

D1049

Parent Item Name: Saddle

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	46.2000	0.1666	3.507368			

M6061T6B0 750X00 250

**

6061-T6 Bar .750 x .250

Location

Loc Qty

Loc Code

MAT003

46.2

120129

46.2

3.51 on 12/01/26

W/O:		WORK ORDER CHANGES					
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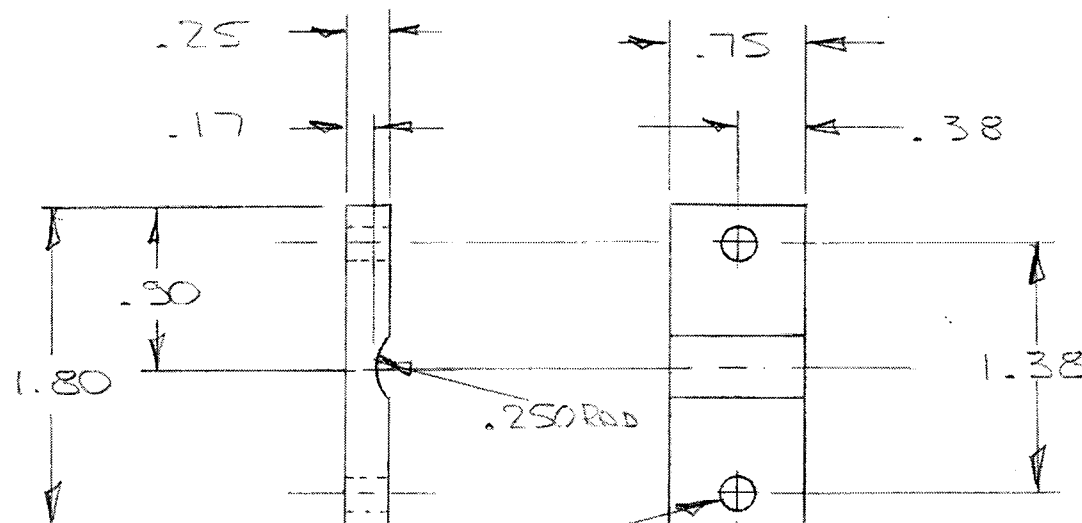
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RELEASED
97/08/02 B.W.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

NO. 79033 M.C.S.
12/01/10



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENOR
DRAWN		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED		BASIC CODE		DRAWN		DATE		
DESCRIPTION OF CHANGE		DIM. DASH NO. B=HEAD REAR SIDE F=HEAD FAR SIDE D=HOLE DASH-HO OF SHEETS K=COUNTERSINK LENGTH DASH NO. W=SPOTWELD BASIC CODES B-P=520H 70AD BB=520H 26AD		12/01/10 1902		TITLE		
		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLE PER AND 10067 1. TOLERANCES — .001 & .002 2. ANGLES 1/2 W 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL H/C CENTRE LINES .005		DART		SADDLE		
		REPORT ALL DISCREPANCIES — DO NOT SCALE		CLIENT		CODE		
						DNG NO		
						D1049		
						SCALE		
						SHT OF		

W/O:		WORK ORDER CHANGES					
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